

5/42

DART AEROSPACE LTD	Work Order:	24338
Description: Bracket Assembly	Part Number:	D3121-041
Dwg: D3121 Rev. C2 page 1, 3, 4 D3121-041 replaces Premier P/N B30-23000-33	Qty:	6 Kits
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler Dwg not required	[Signature]	05.09.26	6												
2	MV	Cut-blank: 1.00" x 2.00" x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>14773</u> Identify for D3121-11	[Signature]	05/10/02	6												
3	MV	Machine as per Folio FA331 and Dwg D3121 Identify as D3121-11	[Signature]	05/10/02	6												
4	QC2	Inspect parts as they come off the CNC machine	[Signature]	05/10/06	6												
5	MV	Deburr. Break all sharp edges 0.005 to 0.015	[Signature]	05/10/06	6												
6	MV	Scribe batch number to D3121-11 at the back face.	[Signature]	05/10/06	6												
7	QC8	Second check of D3121-11	[Signature]	05/10/14	6												
8	GA	Assemble D3121-041 as per Dwg D3121 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3121-21</td><td>Bolt</td><td><u>B 229/4</u></td></tr><tr><td>1</td><td>D3121-241</td><td>Bearing Assy</td><td><u>B21855A</u></td></tr></table>	Qty	Part Number	Description	Batch	1	D3121-21	Bolt	<u>B 229/4</u>	1	D3121-241	Bearing Assy	<u>B21855A</u>	[Signature]	05/10/06	6
Qty	Part Number	Description	Batch														
1	D3121-21	Bolt	<u>B 229/4</u>														
1	D3121-241	Bearing Assy	<u>B21855A</u>														
9	QC5	Inspect work to Step 8	[Signature]	05/10/14	6												
10	ST	Identify and Stock in Spacedoor cell	[Signature]	05/10/19	6												
11	AC	Cost / part: <u>242.31</u>	[Signature]	05.10.20	6												
12	DC	Close W/O <u>157.86</u> Inspect Level 21	[Signature]	05/10/20	6												

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.06.09	Hardware revised in Step 8	KJ/JLM	[Signature]

RELEASED
11/05/08

02.55

W/O: 24338		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 24338		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/02	#3	three parts (2) scrap Both come out of fixture.		scrap/replace and Destroy,	Er 05/10/06	05-10-00		
05/10/02	#3	one part scrap too much cutter comp put one		Remove and cutter comp scrap/replace and Destroy	Er 05/10/06	05-10-00		
05/10/07	#3	It was supposed to be REMOVE THE SAME AMOUNT IN ALL 3 SLOTS QTY OF 1 IT IS ACCEPTABLE?		see attached copy of fax		05-10-11		

Part No: D3121-11 PAR #: Fault Category: Prod / Machine ^{Parts} NCR: Yes No DQA: Date: 05/10/20

NOTE: Date & initial all entries

QA: N/C Closed: Date: 05.10.20

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024338
Project Name : D3121-041
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3121-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24338
Description: Bracket		Part Number: D3121-1 Bracket
Inspection Dwg: D3121	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	± 0.030	0.757	✓			
0.375	± 0.010	0.383	✓			
0.392	± 0.002 -0.000	0.392	✓			
1.96	± 0.030	1.965	✓			
0.650	± 0.010	0.650	✓			
0.300	± 0.010	0.297	✓			
1.250	± 0.010	1.252	✓			
0.201	± 0.005 -0.001	0.201	✓			
0.100	± 0.010	0.103	✓			
0.300	± 0.010	0.304	✓			
0.080	± 0.010	0.078	✓			
0.573	± 0.010	0.573	✓			
R.0.25	± 0.030	0.25	✓			
2.85	± 0.030	2.87	✓			
2.14	± 0.030	2.121	✓			
2.56	± 0.030	2.571	✓			
0.130	± 0.010	0.125	✓			
0.400	± 0.010	0.399	✓			
0.381	± 0.010	0.390	✓			
0.201	± 0.010	0.203	✓			
0.580	± 0.010	0.580	✓			
0.032	± 0.010	0.031	✓			

Measured by: <i>En</i>	Audited by: <i>gm</i>	Prototype Approval: <i>VIA</i>
Date: 05/10/04	Date: 05/10/03	Date: <i>M/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Dart Aerospace Ltd

~~ASSEMBLY AND GROUNDING~~
~~FOR 1-617-632-4443~~

ATTN: ROBERTO PUNTES
FAX: 1-617-632-4443

11/13/2014 14:23 FAX

WIO: 24338		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/02	#3	two points to scrap. Both come out of fixture.		Scrap/Replace and Destroy.	Er 05/10/02	 05-10-02		
05/10/02	#3	one point scrap two more cutter comp put one		Remove and cutter comp scrap/Replace and Destroy	Er 05/10/02	 05-10-02		
05/10/07	#3	It was supposed to be HAWK THE SAME AMOUNT IN ALL 3 SLOTS QTY OF 1 IT IS ACCEPTABLE?		ACCEPTABLE DEVIATION	 05.10.11		 05.10.11	

Part No: D3121-11 PAR#: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

001/001